

Date: Tuesday, 4/18/2006 1:06:24 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : INLET VALVE SHAFT
Job Number : 26713	
Estimate Number : 12252	
P.O. Number : N/A	Part Number : D34747
This Issue : 4/18/2006 S.O. No. : N/A	Drawing Number : D3474 REV.A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 26615	Material : N/A
Written By : <u>SEE COMMENT BELOW</u>	Due Date : 4/25/2006 Qty: 10 Um: Each
Checked & Approved By : <u>CJOG 06/04/18</u>	
Comment : est rev. A 06.02.07 New issue EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	SILF36X36X116	Gasket
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Comment: Qty.: 0.0540 Each(s)/Unit Total : 0.5400 Each(s)

high temp. silicone sheet .125 batch: B 24 473

SB 06/04/19 (12)

2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Dan make as per dwg D3474..... Do it !!!

SB 06/04/19 10

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

ABOLAN 24/10

4.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5# 440

SB 06/04/27 (10)

5.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Inspection Level 21

06/04/28 (10)

Job Completion



U 06.04.28

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/04/28
 QA: N/C Closed: _____ Date: _____

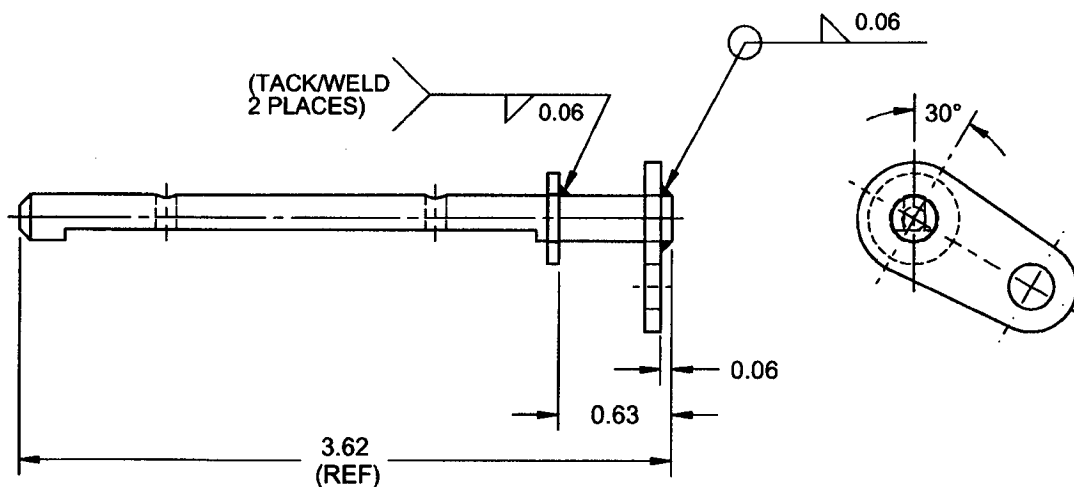
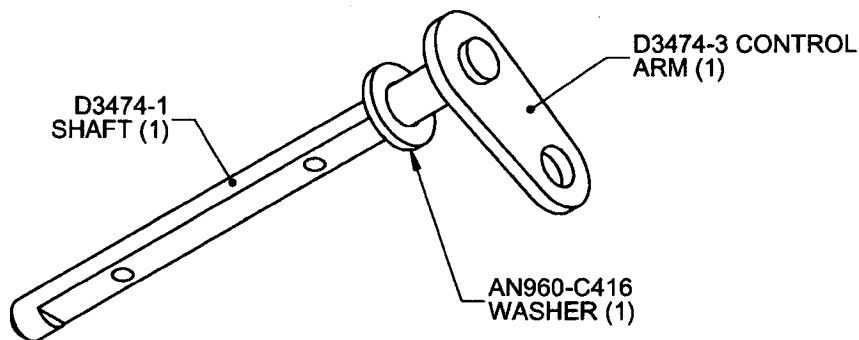
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3474	REV. A SHEET 1 OF 4
DATE 06.01.23		TITLE INLET VALVE SHAFT	SCALE 1:1
A	06.01.23	NEW ISSUE	

[Signature] 06.04.03



REFERENCE ONLY

D3474-041 INLET VALVE SHAFT

NOTES:

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION
X	D3474-041	INLET VALVE SHAFT
1	D3474-1	SHAFT
1	D3474-3	CONTROL ARM
1	AN960-C416	WASHER

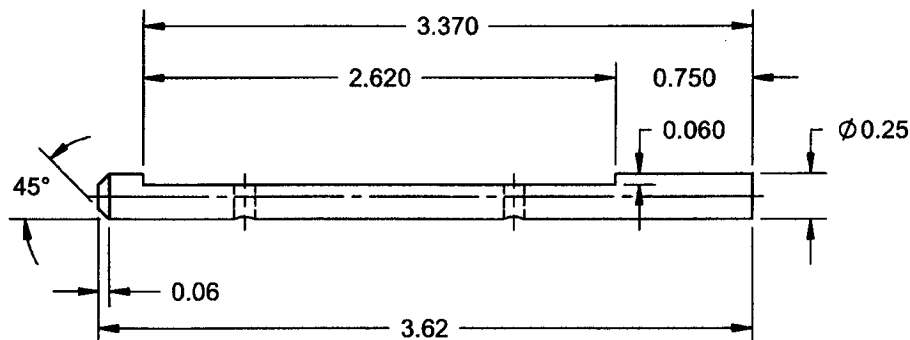
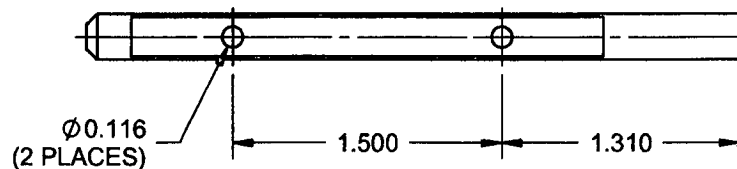
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DATE 06.01.23		TITLE INLET VALVE SHAFT	SCALE 1:1

[Signature] 06.04.03



REFERENCE ONLY

D3474-1 SHAFT

NOTES:

- 1) MATERIAL: AISI 303 STAINLESS STEEL 0.25 ROUND BAR
(REF. DART SPEC. M303R0.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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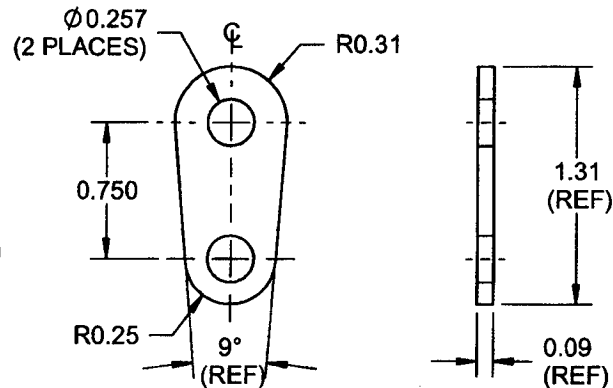
DART

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3474	REV. A SHEET 3 OF 4
DATE 06.01.23		TITLE INLET VALVE SHAFT	SCALE 1:1

06.04.03

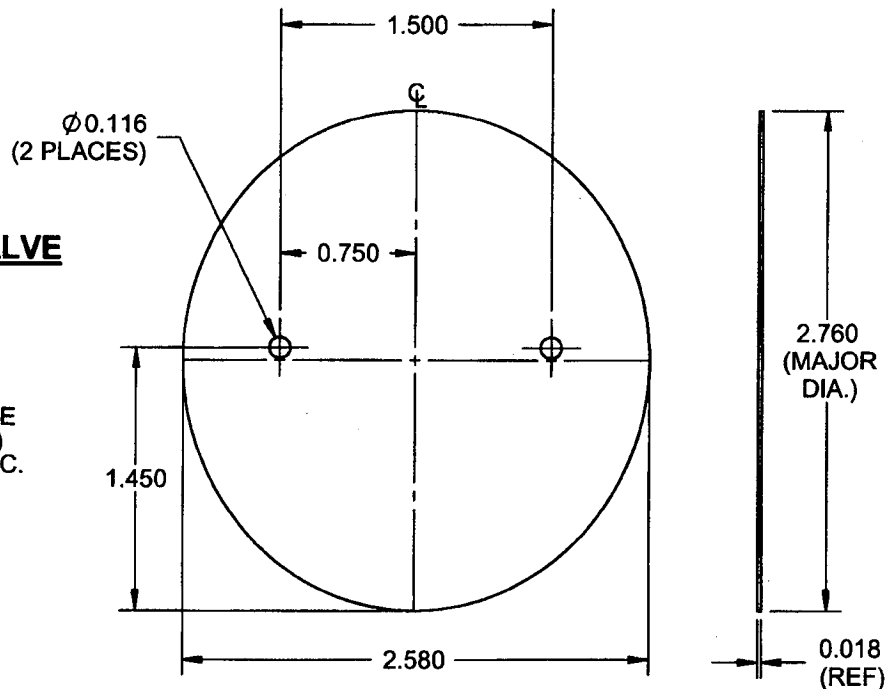
D3474-3 CONTROL ARM FLAT PATTERN

- 1) MATERIAL: AISI 304/316 SS SHEET PER
MIL-S-5019 (ANNEALED) 2B
FINISH 13 GAUGE SS
(0.090 THICK)
(REF. DART SPEC. M304S13GA)



D3474-5 BUTTERFLY VALVE FLAT PATTERN

- 1) MATERIAL: AISI 304/316 SS
SHEET PER
MIL-S-5019
(ANNEALED) 2B
FINISH 26 GAUGE
SS (0.018 THICK)
(REF. DART SPEC.
M304S26GA)



REFERENCE ONLY

NOTES:

- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

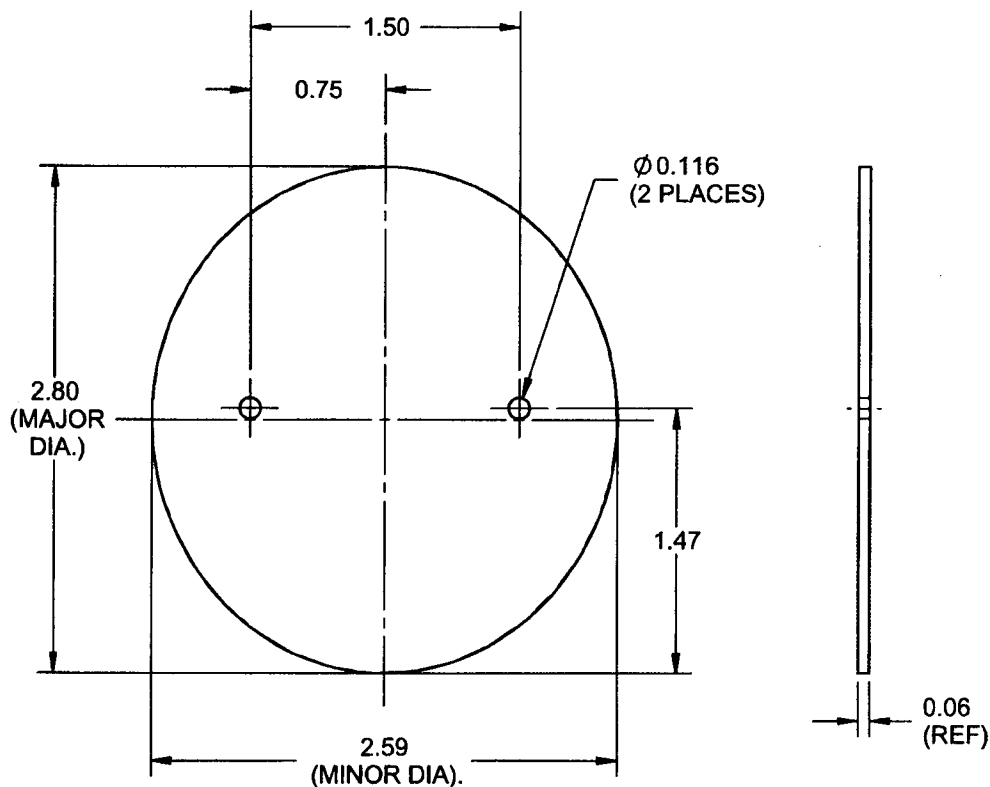
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DESIGN B	DRAWN BY B	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3474	REV. A SHEET 4 OF 4
DATE 06.01.23		TITLE INLET VALVE SHAFT	SCALE 1:1

06.04.03



REFERENCE ONLY

D3474-7 BUTTERFLY VALVE SEAL

NOTES:

- 1) MATERIAL: RED (OR GRAY) 60 DUROMETER HI-TEMPERATURE SILICONE SHEET, 0.063 THICK (REF. DART SPEC. M-SIL60-S.063)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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